

Date: Monday, 12/01/2009 2:34:27 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE	
<b>Job Number</b> : 44624		
<b>Estimate Number</b> : 12243		
<b>P.O. Number</b> :	<b>Part Number</b> : D34773	<i>PER HAND CHANGE</i> <i>29.14</i>
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3477 UNDER REVIEW	
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A	
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A	
<b>Previous Run</b> : 36352	<b>Material</b> :	
<b>Written By</b> :	<b>Due Date</b> : 30/01/2009	<b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.13</u>		
<b>Comment</b> : Est Rev:A New Issue 06-02-07 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.1985 sf(s)/Unit Total: 0.7938 sf(s)  
 304/316 0.018 SHEET  
 (M304S26GA)  
 Batch: 110938

2.0	SHEAR	SHEAR
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**Comment:** SHEAR

Cut as per Dwg D3477 (13.40" X 2.04")

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3477

3-Tack Weld as per Dwg D3477

4.0	QC	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:34:28 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44624

Part Number: D34773

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/03 (Y)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ISS

9/6/2

(4x)

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02 HJ

Job Completion



MF 09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3477	REV. A SHEET 1 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	

~~06.04.03~~  
**UNDER REVIEW**

~~02.09.03~~

~~Dim + Manufacturing  
Changes~~  
~~09.01.14~~

D3477-5 BLOWER  
ADAPTER FLANGE (1)

D3477-3  
TUBE (1)

D3477-1  
FLANGE (1)

ALIGNMENT OF  
SPOT WELD SEAM

Ø7.13  
(REF)

30°

45°

30°

(2 PLACES)

0.50  
(24)

UNCHECKED COPY  
SUBMIT TO THE

2.04

### D3477-041 BLOWER MOTOR INLET ADAPTER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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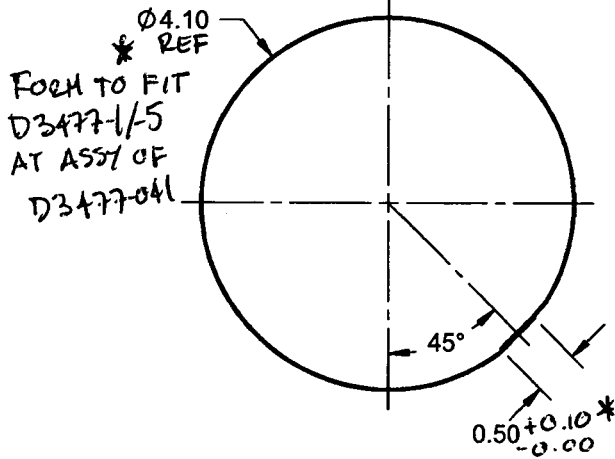
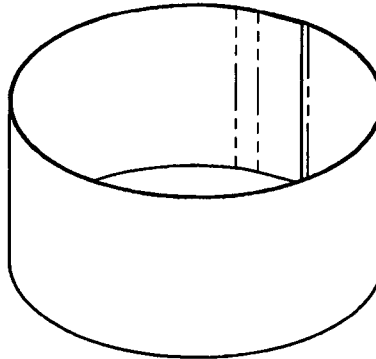
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 3 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

~~06.04/03~~  
**UNDER REVIEW**

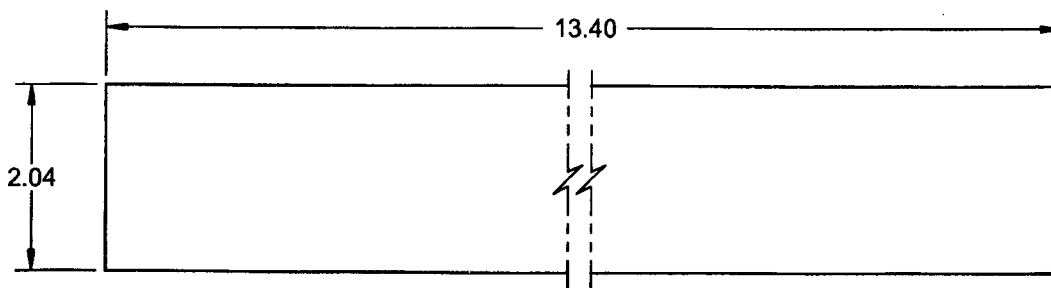
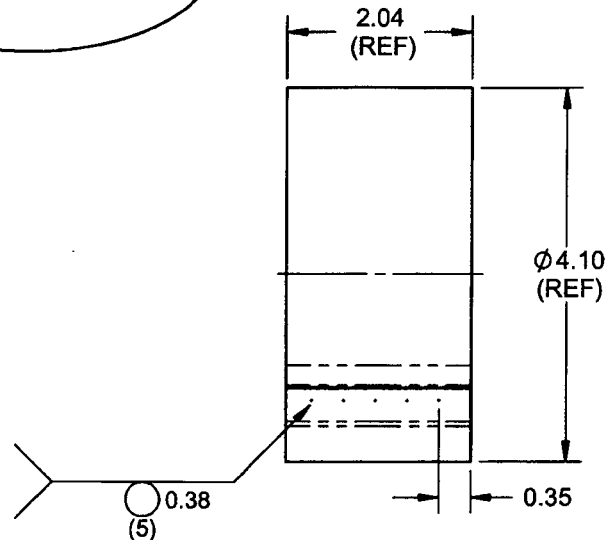
~~02.09/03~~

~~Dim + Manufacturing  
Checks~~

~~09.0.14~~



**D3477-3 TUBE**



**D3477-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
DART AEROSPACE LTD

NO. 44624

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 61

EMPLOYEE: Frans Franken

PART NUMBER: D3477-3

JOB NUMBER: 44624

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <u>-</u> ]	[ ]
PENETRATION:	[ <u>//</u> ]	[ ]
PULL STRENGTH:	[ ]	[ ] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 09/04/02  
QUALIFIER: SP